*05

Page 1

January-03-13	9:31:49 AM											
Item ID: Revision ID:	D3177-5				Accept	*N900	040	100)* s	etup Star	171	S1*
Item Name:	Spacer									Sto	P *N,	S2*
Start Date:	1/04/13	Start Qty: 10.00)	*10*		Cust Item I	D:					
Required Date:	1/04/13	Req'd Qty: 10.00)	*10*		Customer:						
Reference:												
Approvals:	Process Plan	n:				Da	ite:		R	Run Star Sto	1/1	R1*
	QC:		Date: _		SPC (Y/N):	Da	ıte:			310	^۲ *N	R2*
Sequence ID/ Work Center II		Operation Description			Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Staup
Draw Nbr	Revi	sion Nbr								100 100		(04
D3177	Rev	B2										
100					0 00							04
100		Hardinge CNC LATH	E SMALL			、	(-	4	10			(0 4
Hardinge		Memo			0.00	,			- &			
Hardinge CNC Lath	e Small	I-TURN A	AS PER FOLIC) FA292 & DV	WG FOLIO REV: M	<u>Z</u>						
		DWG RE	v:									
		2-DEBUR	R AS REQUII	RED		•						ARA.
110 *4.4 \(\D\)*		QC2- Inspect parts off	machine FAI/F	FAIB	0.00	(3 · (. (,	10			70AS 04 9-8
110 QC Quality Control		Memo			0.00	(/ (†				

											DQA:	Date	:
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UPDATE				,
											QA Closed:	Date	:
Work Ord	or:					DISPOSITION			AG	GAINST DEI	PARTMENT	PROCESS	
Work Ord	е.					Rework	1		Skid-tube Cro	sstube		Water Jet	Engineering
Part I	No.					Scrap		I	├	nall Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is]	Therm	noforming Fir	nishing	Rec/Stor	e/Packaging	Other
NCR I	No.					Work Order Update]	1	Large Fab Com	nposite		Supplier	
Root			I		Descri	ption of work order update	Т	Initial	Action		Sign &		
Cause		Date	Step	Qty	l	or Non-conformance	1	nief Eng	Description	1	Date	Verification	QC Inspector
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Material										:			
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
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Landi	ng (Gear				General	_	-				-	
	Bending					Bend	L	Grain			Ovalized	L	Pressure/Forced
	Centre Not Concentric to O/S				o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped.					Burrs	Instructions Incomplete/Unclear			r	Part Lost/M	issing	Wrong Stock Pulled
	1	Cuffs			1	Contamination	Maintenance				Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde January-03-13		5228		*952	228*						Page 2
Item ID: Revision ID: Item Name:	D3177-5 Spacer			Accept	*N900	040	100)*	Setup Star	17	S1*
Start Date: Required Date: Reference:	1/04/13 1/04/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item Customer:					1 4	
Approvals:	Process Pl	an:	Date:		· · · ·)ate:		I	Run Star Stop	, I/I	R1* R2*
Sequence ID/ Work Center II	D	Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control		Мето		0.00				10			13.04.04
121		Chemical Conversion Coa	at per QSI005 4.1	0.00				40	H	Ž 12	12
171 HandFinish Hand Finishing		Memo		0.00				10	M	1_10	/-/_
123 * 1 23*		QC7-Inspect Chemical Co	onversion Coat	0.00 Sm_	1			10			
QC		Memo		0.00 13-1-							

Quality Control

											DQA:	Date:	,
NCR:	⁄es	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE	•		:
		•									QA Closed:	Date:	
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Work Orde	er.					Rework	ı		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	Nio					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
raici	١٠.					Use-as-is	1	1	noforming	Finishing	4	re/Packaging	Other
NCR I	Vo.					Work Order Update			Large Fab	Composite	1	Supplier	
									ů L	· <u>L</u>			· — —
Root					Descri	ption of work order update	Ti	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material				<u> </u>									
Setup				7									
Other													
Process													
Supplier													
Training													:
Unapproved													
						F	AUI	T CATE	GORY				
Landi	ng (Gear			_	General		•			7		٦
	Bending Bend						L	Grain			Ovalized		Pressure/Forced
						BOM/Route	Hardware			Over/Under tolerance		Temperature/Cure	
	L	Cracks			L	Broken/Damaged		Inspect	ion Incomplete	<u> </u>	Part Incorre	ct	Weld
	Crushed/Crimped Burrs							Instruct	tions Incomplete	/Unclear	Part Lost/Missing		Wrong Stock Pulled

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-03-13 9:51:49 AM D3177-5 Item ID: Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Spacer 1/04/13 **Start Qty: 10.00 Start Date: Cust Item ID:** Required Date: 1/04/13 Req'd Qty: 10.00 **Customer:** Reference: Date:_____ **Tooling:** Approvals: Process Plan: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Set Up/ Reject Operation Tool ID Tool # Plan Accept Reject Insp. Qty Number Stamp **Work Center ID** Description **Run Hours** Code 130 Identify as per dwg & Stock Location: 0.00 *120* Packaging 0.00 Memo Packaging QC21- Final Inspection - Work Order Release 140 0.00 MCS 13-01-07 MF *140* 0.00 Memo Quality Control

Equip/Tooling Operator Operator Omega of the control of the contro											DQA:	Date:	
Work Order: Part No.	NCR: Y	es / No)			WORK ORDER NON-C	ON	IFORM	MANCE / UPDA	ATE			
Part No.										-	QA Closed:	Date:	
Rework Scrap Use-as-is Work Order Update Use-as-is Gameral Equip/Tooling Update Under I Initial Action Description of work order update	Work Ordo	vr.				DISPOSITION				AGAINST DEF	PARTMENT	PROCESS	
Root Cause Date Step Qty Description of work order update or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Operator						Scrap Use-as-is			Machining	Small Fab		d. Eng. Coor.	Quality
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Operator	NCR N	lo				Work Order Update]		Large Fab	Composite		Supplier	
Doc/Data	Root				Descri	ption of work order update	1	nitial	Actio	on	Sign &		
Equip/Tooling Operator	Cause	Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
Material Setup Other Oth	Doc/Data Equip/Tooling												
Other Process Supplier Training Unapproved Supplier Tealing Unapproved Supplier Totaling Cear General Bending Gear Centre Not Concentric to O/S Control Not Concentric to O/S Broken/Damaged Supplier Inspection Incomplete Part Incorrect Weld	Material												
Process Supplier Training Unapproved Bending Centre Not Concentric to O/S Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Part Incorrect Weld Weld Par	Setup												
Supplier Training Unapproved Training Unapproved FAULT CATEGORY FAULT CATEGORY Landing Gear General Bending Centre Not Concentric to O/S Cracks BOM/Route Broken/Damaged Grain Hardware Unspection Incomplete Description of the concentric to O/S Description of the con	Other												
Training Unapproved Training Unapproved Training Unapproved Training Unapproved Training Gear FAULT CATEGORY Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Inspection Incomplete Part Incorrect Weld	Process											1	
FAULT CATEGORY FAUL	Supplier												
FAULT CATEGORY Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld	Training												
Landing Gear General Bending Centre Not Concentric to O/S Cracks General Grain Grain Hardware Hardware Unspection Incomplete Part Incorrect Weld	Unapproved												<u> </u>
Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld							AUL	T CATE	GORY				<u> </u>
Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Broken/Damaged Inspection Incomplete Part Incorrect Weld	Landir	_				7		ا ما			۱		7. /
Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld		_	_	- L	4	\vdash			-		– –	┥ '	
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	1 🖼 🗀				<u> </u>	1	_			 	ĺ	<u> </u>	-
Courte Maintenance Dant Maintenance]		a/Crimped			-1	_	1		nciear		issing	Twitoug Stock Fulled
Cuffs Contamination Maintenance Part Moved Heat Treat Countersink Mislabeled Positioned Wrong			roat		-				Maintenance		Part Moved		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short Drill Holes

Drawing

Finish

Folio

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-03-13 9:51:49 AM

Work Order ID:

95228

Parent Item:

D3177-5

Parent Item Name:

Spacer

Start Date: 1/04/13

Required Date: 1/04/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A03.01.27New IssueKJ/RF

Comments:	IFF AUS.UI.Z/INCV	v 155ucKJ/KI											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000 ROUND BAR 1.00"		Purchased	No				f	74.2190		0.8	an depe		***
				Location		Loc Qty	<u>Lo</u>	c Code					CA.
				MAT012		24				<u>. </u>	15.1	. 4	04
				121	070	24						•	9-89
				MAT013		50.219							
				116	406	12.103							
				118	271	11.4							
				121	192	9.64							
				122	521	10			1-143	5,			
				123	483	7.076			ū	,			

											DQA	: Date:	
NCR: Y	⁄es	/ No				WORK ORDER NON-C	100	NFOR	MANCE / UP	DATE			
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Part N	No.					Scrap	1 1	1	Machining	Small Fab	Pro	od. Eng. Coor.	Quality
	-					Use-as-is			noforming	Finishing	l .	ore/Packaging	Other
NCR N	No.					Work Order Update			Large Fab	Composite		Supplier	
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Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	Ш									•			
Equip/Tooling	Ш						ŀ						
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Material													
Setup													
Other													
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Supplier													
Training													
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Landi	Landing Gear General												
		Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S					BOM/Route			Hardware		Over/Under tolerance		Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Outside Dimensions

Out of Sequence

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Broken/Damaged

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

Burrs

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

		(A) (') () () ()
D3065-5DART AEROSPACE LTD	Work Order:	77600
Description: Spacer	Part Number:	D3177-5
Inspection Dwg: D3177 Rev: B2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST														
		X First Artic	cle	Prot	otype									
Drawing	Tolonomoo	Actual	Assent	Daiget	Method of		nments							
Dimension	Tolerance	Dimension	Accept	Reject	Inspection		ninents							
0.838	+/-0.010	- 136			D. 0	2								
0.383 - 0.381	N/A	- 382												
0.626	+0.001/-0.000	. 626												
0.455	+/-0.010	. 455	\											
Ø1.000	+/-0.005	. 997												
0.063 x 45°	+/-0.010	.0.63												
Ø0.323	+0.005/-0.000	. 325												
-														
						-								
	NO.S		D4.											
Measured by:	11 3-83	Audited by:	D4 2330		Prototype	Approval:	N/A							
Date:	1 2 2	Date:	13.01.0	, –1		Date:	N/A							
Rev Date	Change					Revised by	Approved							
A 04.02.25						KJ/RF	Approved							

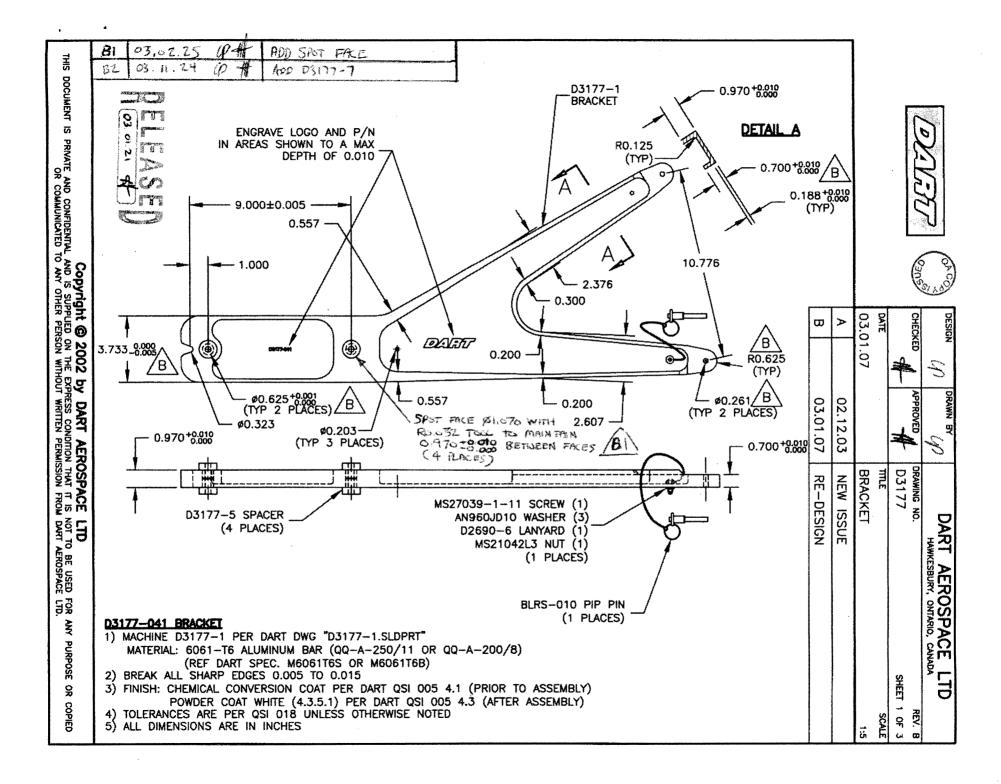
												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	ANCE / UPDA		_	•	
												QA Closed:	Date:	
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Part !	No.						Rework Scrap Use-as-is Work Order Update		Therm	Machining noforming	Crosstube Small Fab Finishing Composite		Water Jet I. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
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Root Cause		Date	Step	Qty	Des	-	otion of work order update r Non-conformance	ı	nitial ief Eng	Actio Descrip		Sign & Date	Verification	QC Inspector
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Landi	ng (Gear					General					_		
		Bending					Bend		Grain			Ovalized	ļ	Pressure/Forced
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		Cracks					Broken/Damaged		Inspect	on Incomplete		Part Incorred	t	Weld
	Crushed/Crimped. Burrs								Instruct	ions Incomplete/Un	clear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Contamination								Mainte		-	Part Moved		
		Heat Trea					Countersink	<u>_</u>	Mislabe			Positioned V		ا ا
	<u> </u>	Inspection	n Strip in	Tube			Cut Too Short		Misread	I		Power Loss/	Surge	Other
	L	Ripples in	Bend				Drill Holes	L	Offset			**************************************		
		Torque W	aves in E	Extrusio	า		Drawing		Out of (Calibration				
		Torque Waves in Extrusion Drawing Out of Calibration												

Outside Dimensions

Wave/Twist in Tube

Folio

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		DQA:	Date:	•
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
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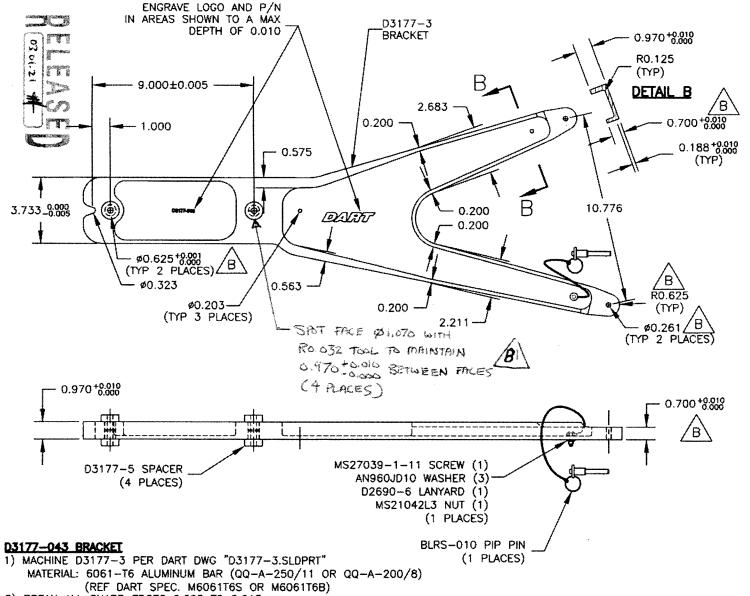
											QA Closed:	Dat	e:	
Work Orde	er:					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS		
	•	···········				Rework	1		Skid-tube	Crosstube		Water Jet		Engineering
Part I	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	\exists	Quality
	•					Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	e/Packaging		Other
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier		
Root					Descri	ption of work order update	1	nitial	Act	tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	1	QC Inspector
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Training														
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Landi	ng (Gear				General					-	-		
		Bending				Bend		Grain		<u>L.</u>	Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct		Weld
		Crushed/	Crimped.			Burrs		Instruct	tions Incomplete/	'Unclear	Part Lost/M	issing		Wrong Stock Pulled
	Cuffs					Contamination		Mainte	enance		Part Moved			
ļ	Heat Treat					Countersink		Mislabe	eled		Positioned \	Vrong		,
	Inspection Strip in Tube					Cut Too Short		Misrea	d		Power Loss	'Surge		Other
	Ripples in Bend					Drill Holes		Offset						
	Torque Waves in Extrusion					Drawing		Out of	Calibration					
	Turning Sequence					Finish		Out of	Sequence					
	Wave/Twist in Tube					Teolio	Outside Dimensions							







BRACKET 1:5		03.01.07	
TITLE SCALE		DATE	
D3177 SHEET 2 OF 3	¥	#	
DRAWING NO. REV. B	APPROVED M DRAWING NO.	CHECKED 7	3
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWN BY	DESIGN (A)	81 7 E



- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (PRIOR TO ASSEMBLY) POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 (AFTER ASSEMBLY)
- 4) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

THIS.

DOCUMENT

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PURPOSE

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COPIED

NCR:	Yes	/	No
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DQA: _____ Date: ____

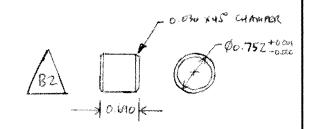
NCR:	Yes	/ No				WORK ORDER NON-O		NFORN	//ANCE / UP	DATE				
											QA Closed:	Date:		
Vork Order:						DISPOSITION		AGAINS'			DEPARTMENT/PROCESS			
Part No.						Rework Scrap		i e	Skid-tube Machining	Crosstube Small Fab	Prod	Water Jet d. Eng. Coor.	Engineering Quality	
NCR No.						Use-as-is Work Order Update		I		Finishing Composite	Rec/Store/Packaging Supplier		Other	
Root Descri					Descr	iption of work order update		Initial Action		Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector	
oc/Data														
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	Cracks					Broken/Damaged		Inspecti	on Incompl <u>e</u> te		Part Incorre	ct	Weld	
	Crushed/Crimped.					Burrs	Instru		structions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled	
	Cuffs					Contamination	ШМã		Maintenance		Part Moved			
	Heat Treat					Countersink	ntersink		Mislabeled		Positioned Wrong			
	Inspection Strip in Tube					Cut Too Short		Misread			Power Loss/Surge		Other	
	Ripples in Bend				Drill Holes		Offset							
		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration					
		Turning So	equence			Finish		Out of S	Sequence					
	Wave/Twist in Tube					Folio		Outside	Dimensions					

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	DESIGN (DRAWN BY		EROSPACE LTD JRY, ONTARIO, CANADA		
/	CHECKED	APPROVED N	DRAWING NO.		REV.	В
	4	ar	D3177	SHEET	3 OF	3
ı	DATE	······································	TITLE		SCA	LE
	03.01.07		BRACKET		1	1:1



D3177-7 PUG-

0.838
(REF)

0.383

0.381

0.626+0.001 0.D.

0.0626+0.000 0.D.

0.063"x45" CHAMFER

0.0838

0.0838

0.383

0.381

0.383

0.381

0.383

0.381

D3177-5

1) MATERIAL: 6061-T6 ALUMINUM BAR Ø1.000

(QQ-A-200/8 OR QQ-A-225/8)

(REF DART SPEC. M6061T6R1.000)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



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DQA: ____ Date:

NCR: Y	es / No				WORK ORDER NON-C	CONFOR	RIVIAINCE / UP	DATE	QA Closed:	Date	:
Work Orde	r•	•••			DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part N			-		Rework Scrap]	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality
NCR No.					Use-as-is Work Order Update	1		Finishing Composite			
Root Descri					iption of work order update	Initial Action		ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	g Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator	_			·	s Šv						
Material	_	1									
Setup	up						1				
Other	r 📙										
Process											
Supplier	_										
Training											
Unapproved		J				AULT CA	TEGODY			<u> </u>	
Landin	g Gear				General	AULI CA	ILGONI				
[Bending				Bend	Grain	1	Г	Ovalized	Г	Pressure/Forced
}	Centre Not Concentric to O/S				BOM/Route	Hard		-		tolerance	Temperature/Cure
F	Cracks				Broken/Damaged	—	Inspection Incomplete		Part Incorrect		Weld
	Crushed/Crimped				Burrs	Instructions Incompl		/Unclear	Part Lost/Missing		Wrong Stock Pulled
ļ	Cuffs			<u> </u>	Contamination		intenance		Part Moved		
ľ	Heat Treat				Countersink	Misla	Mislabeled		Positioned Wrong		
	Inspection Strip in Tube				Cut Too Short	Misre	Misread		Power Loss,	/Surge	Other
Ī	Ripples in	Bend			Drill Holes	Offse	t				
	Torque W	aves in l	extrusio	n [Drawing	Out	of Calibration				
	Turning Sequence				Finish	Out	of Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G